Dart Aerospace Ltd. Wednesday, 5/23/2007 3:24:41 PM Date: User: Kim Johnston **Process Sheet** : DOUBLER **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services Job Number : 32473 : 12105 Estimate Number : NIA : D32011 P.O. Number Part Number : D3201 REV B : 5/23/2007 A) 4: .01 .0.2 This Issue **Drawing Number** : N/A Prsht Rev. : NC Project Number MA First Issue Type : SMALL /MED FAB : B **Drawing Revision** : 30827 Previous Run Material : 6/6/2007 Qty: 20 Um: Due Date Written By Checked & Approved By Removed from 9 Digit 06-01-25 JLM Comment Est Rev:B Now on Waterjet 06-08-14 JLM **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: M2024T3S040 1.0 2024-T3 .040 sheet Comment: Qty.: 0.2898 sf(s)/Unit Total: 5.7960 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Identify for D3201-1 07/06/00 Batch: FLOW WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D3201 Dwg Rev:\_\_ Prog Rev:\_\_\_ 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07106106

QC8

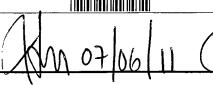
Comment: SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1

SMALL FAB 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack



4.0

5.0

Each

## **Dart Aerospace Ltd**

| DuitAc  | oopacc . | Liu                       |        |           |            |                                     |                          |  |  |  |  |
|---------|----------|---------------------------|--------|-----------|------------|-------------------------------------|--------------------------|--|--|--|--|
| W/O:    |          | WORK ORDER CHANGES        |        |           |            |                                     |                          |  |  |  |  |
| DATE    | STEP     | PROCEDURE CHANGE          | Ву     | Date      | Qty        | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |  |  |  |
|         |          |                           |        |           |            |                                     |                          |  |  |  |  |
|         |          |                           |        |           |            |                                     |                          |  |  |  |  |
|         |          |                           |        |           |            |                                     |                          |  |  |  |  |
|         |          |                           |        |           |            |                                     |                          |  |  |  |  |
| Part No | :        | PAR #: Fault Category: NO | CR: Ye | s No DQ   | A: <u></u> | Date: _                             | 7106/14                  |  |  |  |  |
|         |          |                           | QA:    | N/C Close | d:         | _ Date: _                           |                          |  |  |  |  |
| NCR:    |          | WORK ORDER NON-CONFORMANC | E (NC  | CR)       |            |                                     |                          |  |  |  |  |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |  |                              |                |           |                       |                          |  |  |  |  |
|------|------|----------------------------------|--|------------------------------|----------------|-----------|-----------------------|--------------------------|--|--|--|--|
|      |      | Description of NC                | Description of NC Corrective Action Section B Verification |                              |                |           |                       |                          |  |  |  |  |
| DATE | STEP | Section A                        | Initial<br>Chief Eng                                       | Action Description Chief Eng | Sign &<br>Date | Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |  |  |  |  |
|      |      |                                  |  |                              |                |           |                       |                          |  |  |  |  |
|      |      |                                  |  |                              |                |           |                       |                          |  |  |  |  |
|      |      |                                  |  |                              |                |           | :                     |                          |  |  |  |  |
|      |      |                                  |  | : '                          |                |           |                       |                          |  |  |  |  |
|      |      |                                  |  |                              |                |           |                       |                          |  |  |  |  |
|      |      |                                  |  |                              |                |           |                       |                          |  |  |  |  |
|      |      |                                  |  |                              |                |           |                       | •                        |  |  |  |  |
|      |      |                                  |  |                              |                |           |                       |                          |  |  |  |  |
|      |      |                                  |  |                              |                |           |                       |                          |  |  |  |  |
|      |      |                                  |  |                              | -              |           |                       |                          |  |  |  |  |

NOTE: Date & initial all entries

Wednesday, 5/23/2007 3:24:41 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: DOUBLER Customer: CU-DAR001 Dart Helicopters Services Part Number: D32011 Job Number: 32473 Job Number: Description: Seq. #: Machine Or Operation: HAND FINISHING RESOURCE #1 HAND FINISHING 6.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 POWDER COAT/CHEMICAL CONVERSION PACKAGING 1 PACKAGING RESOURCE #1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

## Dart Aerospace Ltd

| W/O:    |          |        | WORK ORDER         | CHANGES  |        |           |     |                                     |                         |
|---------|----------|--------|--------------------|----------|--------|-----------|-----|-------------------------------------|-------------------------|
| DATE    | STEP     | PF     | ROCEDURE CHANGE    |          | Ву     | Date      | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approva<br>QC Inspector |
|         |          |        |                    |          |        |           |     |                                     |                         |
|         |          |        |                    |          |        |           |     |                                     |                         |
|         | <b>3</b> |        |                    |          |        |           |     |                                     |                         |
|         |          | W      | ,                  |          | _      |           |     |                                     |                         |
| Part No | :        | PAR #: | Fault Category:    | NCI      | R: Yes | No DQ     | A:  | _ Date: _                           |                         |
|         |          |        |                    |          | QA:    | N/C Close | d:  | _ Date: _                           |                         |
| NCR:    |          |        | WORK ORDER NON-CON | FORMANCE | (NC    | R)        |     |                                     |                         |

| NCR:      |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                              |                |                        |                       |                          |  |  |  |
|-----------|------|----------------------------------|-----------------------------|------------------------------|----------------|------------------------|-----------------------|--------------------------|--|--|--|
| DATE STEP |      | Description of NC                | Corrective Action Section B |                              |                |                        |                       |                          |  |  |  |
| DATE      | STEP | Section A                        | Initial<br>Chief Eng        | Action Description Chief Eng | Sign &<br>Date | Verification Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |  |  |  |
|           |      |                                  |                             |                              |                |                        |                       |                          |  |  |  |
|           |      |                                  |                             |                              |                | · ·                    |                       |                          |  |  |  |
|           |      |                                  |                             |                              |                |                        |                       |                          |  |  |  |
|           |      |                                  |                             |                              |                |                        |                       |                          |  |  |  |
|           |      |                                  |                             |                              |                |                        |                       |                          |  |  |  |
|           |      |                                  |                             |                              |                |                        |                       |                          |  |  |  |
|           |      |                                  |                             |                              |                | 4                      | i i                   |                          |  |  |  |
|           |      |                                  |                             |                              |                |                        |                       |                          |  |  |  |
|           |      |                                  |                             |                              |                |                        |                       |                          |  |  |  |

NOTE: Date & initial all entries

| DART AEROSPACE LTD           | Work Order:  | 32473       |
|------------------------------|--------------|-------------|
| Description: Doubler         | Part Number: | D3201-1     |
| Inspection Dwg: D3201 Rev: B |              | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

|                      |           | X First A           | rticle   | Prot         | otype                   |          |
|----------------------|-----------|---------------------|----------|--------------|-------------------------|----------|
| Drawing<br>Dimension | Tolerance | Actual<br>Dimension | Accept   | Reject       | Method of<br>Inspection | Comments |
| R0.50                | +/-0.030  | Ro.50               | /        |              | R-6                     |          |
| 3.57                 | +/-0.030  | 3,57                |          |              | Vleight g               | a        |
| R0.12                | +/-0.030  | RO,12               |          |              | R-6                     | <i>3</i> |
| 8.00                 | +/-0.030  | 8.009               | <b>\</b> |              | Vern                    |          |
| 0.58                 | +/-0.030  | 8.009<br>0.58       | <b>✓</b> |              | Height su               |          |
| 4.89                 | +/-0.030  | 4,90                |          |              | Vern                    |          |
| R0.25                | +/-0.030  |                     |          |              | R-6                     |          |
| 0.040                | +/-0.010  | 0.039               |          |              | Vern                    |          |
|                      |           |                     |          |              |                         | . 193    |
|                      |           |                     |          |              |                         |          |
|                      |           |                     |          | ****         |                         |          |
|                      |           |                     |          |              |                         |          |
|                      |           |                     |          |              |                         |          |
|                      |           |                     |          |              |                         |          |
|                      |           |                     |          |              |                         |          |
|                      |           |                     |          |              |                         |          |
|                      |           |                     |          |              |                         |          |
|                      |           |                     |          |              |                         | ·        |
|                      |           |                     |          | <del> </del> |                         |          |
|                      |           | :                   |          | <del> </del> |                         |          |
|                      |           |                     | ·        |              |                         |          |

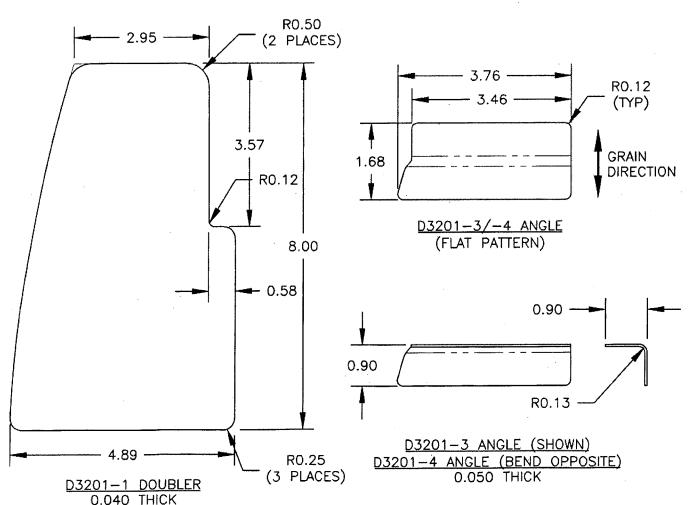
| Date: N/A                | Measured by: | SAN     | Audited by: | MS       | Prototype Approval: | N/A |
|--------------------------|--------------|---------|-------------|----------|---------------------|-----|
| Date: 07/06/06 Date: N/A | Date: رح     | 1/06/66 | Date:       | 20/20/10 | Date:               | N/A |

| Rev | Date     | Change    |                  | <br>Revise |     |   | Approved |
|-----|----------|-----------|------------------|------------|-----|---|----------|
| Α   | 03.11.28 | New Issue | P/O D412-698-015 | <br>KJ/RF  | oZ. | 1 |          |





|   | DESIG | #     | DRAWN BY  | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
|---|-------|-------|-----------|--|
| ' | CHECH | (ED , | APPROVED_ | DRAWING NO. REV. B                             |
|   |       | -4-   | #         | D3201 SHEET 1 OF 1                             |
|   | DATE  |       |           | TITLE SCALE                                    |
|   | 03:1  | 1.03  |           | DOUBLER 1:2                                    |
|   | Α     |       | 03.08.07  | NEW ISSUE                                      |
|   |       |       | 03 11 03  | MODIFY D3201-1 ADD D3201-3/-4                  |



## D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4) (REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.